

Work Order ID 56329

February 17, 2010 2:40:48 PM

Page 1

Item ID: D3211-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 2/17/10 Start Qty: 6.00

Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 6.00

Customer:

Reference:

Run Start

Approvals: Process Plan: *M*

Date: *10-2-17*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3211	Rev A1
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100	0.00
-----	------



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3211 ☐ Dwg Rev: *A1* ☐ Prog Rev: *A1* ☐ 12-
Deburr if necessary

2024-063

B 10-2-23
B 10-2-24

(8)

110	0.00
-----	------



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B 10-2-23
B 10-2-24

→ (9)

Pk →

120	0.00
-----	------



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

→ 8.10.26


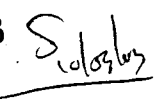


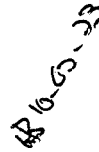

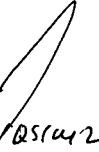

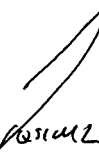
(X)

Pk →

Dart Aerospace Ltd

W/O: 56329		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-02-23	W/O header chg	include DEO into chng box per NCR below				<i>[Signature]</i> 10-02-23	<i>[Signature]</i> 10-02-23
10-02-24	# 120	Took Qty +1 For QC inspection template <i>perm change</i>	<i>[Signature]</i>	10-03-11			
			<i>[Signature]</i>	10-02-24	H		<i>[Signature]</i> 10-02-24

Part No: D3211-1 PAR #: _____ Fault Category: Prod Eng care. NCR: Yes No DQA: *[Signature]* Date: 10-02-23
 Resolution: Scrap Disposition: Scrap. QA: N/C Closed: *[Signature]* Date: 10/03/16

NCR: 56329		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/02/23	# 110	B Found during inspection that the DEO was not attached to w/o. After pulling up DEO it was noticed that the Grain Direction was in the wrong Direction.	 10-02-23	- Scrap + Destroy Qty x 8 Parts. - Add DEO to chng box header	SAD 10-02-23	 S. Solosky	 Kasruar	S 10/02/23
		R.C. worker Jet operator cut in Direction on Dwg. Didn't notice that DEO was missing. DEO wasn't attached by worker to the part person . attached	 Kasruar	- Replace on this w/o in 113866 x 9 with correct Grain Direction	 10-03-23	 S. Solosky	 Kasruar	S 10/02/23
			 Kasruar	→ Retrain both employees involved that DEO was missing and should ask why. → should be attached to work upon			 Kasruar	S 10/02/23

NOTE: Date & initial all entries

W/O release.

Work Order ID 56329

February 17, 2010 2:40:48 PM



Page 2

Item ID: D3211-1

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Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 2/17/10 Start Qty: 6.00



Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

0.00

Memo
Deburr

N/A

0.00

Small Fab

140



Brake NC

NC BRAKE

0.00

Memo

Bend D3211-1 Stack as per Dwg D3211

0.00

So 10/03/02

7

Brake NC

(PTU)

150



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Swloslos

(+7)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3211-1 PAR #: _____ Fault Category: Small Fab NCR: Yes No DQA: [Signature] Date: 10-03-16
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 10/03/16

NCR: <u>56329</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10-03-02</u>	<u>140</u>	<u>1 part cracked during bending.</u> <u>with a 1/8" crack</u> <u>R.C. process</u>	<u>[Signature]</u> <u>DS/CL</u>	<u>Use a 0.156" tool. → part</u> <u>does not appear to crack &</u> <u>meets dwg. dims.</u>	<u>SA</u> <u>10/03/02</u>	<u>S</u> <u>10/03/02</u>	<u>[Signature]</u> <u>DS/CL</u>	<u>[Signature]</u> <u>10/03-02</u>

NOTE: Date & initial all entries

Work Order ID 56329

February 17, 2010 2:40:48 PM



Page 3

Item ID: D3211-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 2/17/10

Start Qty: 6.00



Cust Item ID:

Required Date: 2/24/10

Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

Handwritten: 10/03/04

Handwritten: (X7)

Handwritten: Ø

170

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

Handwritten: 12:30

OVEN TEMPERATURE:

FINISH TIME:

Handwritten: 320°F

Handwritten: 11/05642, 10/03/04, (X7), Ø

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Handwritten: BR 10-3-4.

Handwritten: (7)

Handwritten: X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56329

February 17, 2010 2:40:48 PM



Page 4

Item ID: D3211-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 2/17/10

Start Qty: 6.00



Cust Item ID:

Required Date: 2/24/10

Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location 211

0.00



Packaging

Memo

0.00

Packaging

10-3-5

7x

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/11

MF

10-3-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 17, 2010 2:40:52 PM

Page 1

Work Order ID: 56329



Parent Item: D3211-1



Parent Item Name: Bracket

Start Date: 2/17/10

Required Date: 2/24/10

Comments: IPP Rev:A New Issue 05-11-17 JLM
IPP Rev:B Now on Waterjet 06-10-24 JLM

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	199.6696	8.8737	12.		



2024-T3 .063 sheet



10-2-23
10-2-24 → 9

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

MAT

199.6696242

102942

1.5

105916

1.09

109463

0.00947368

110980

5.4854

111787

12.2847505

113866

81.3

113867

96

19059

2

113866

8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



DESIGN		DRAWN BY		DART AEROSPACE LTD	
HAWKESBURY, ONTARIO, CANADA					
CHECKED	APPROVED	DRAWING NO.	REV. A	SHEET 1 OF 2	
DATE		D3211		SCALE	
03.09.03		BRACKET		1:3	
		NEW ISSUE		CHANGE ALL BEND RADII TO R0.125	

RELEASED
03.09.15

DEO ATTACHED

D3211-1 BRACKET

MACHINE PER DRAWING FILE "D3211-A2.DWG"

CHECK PER TEMPLATE D3211-1T1

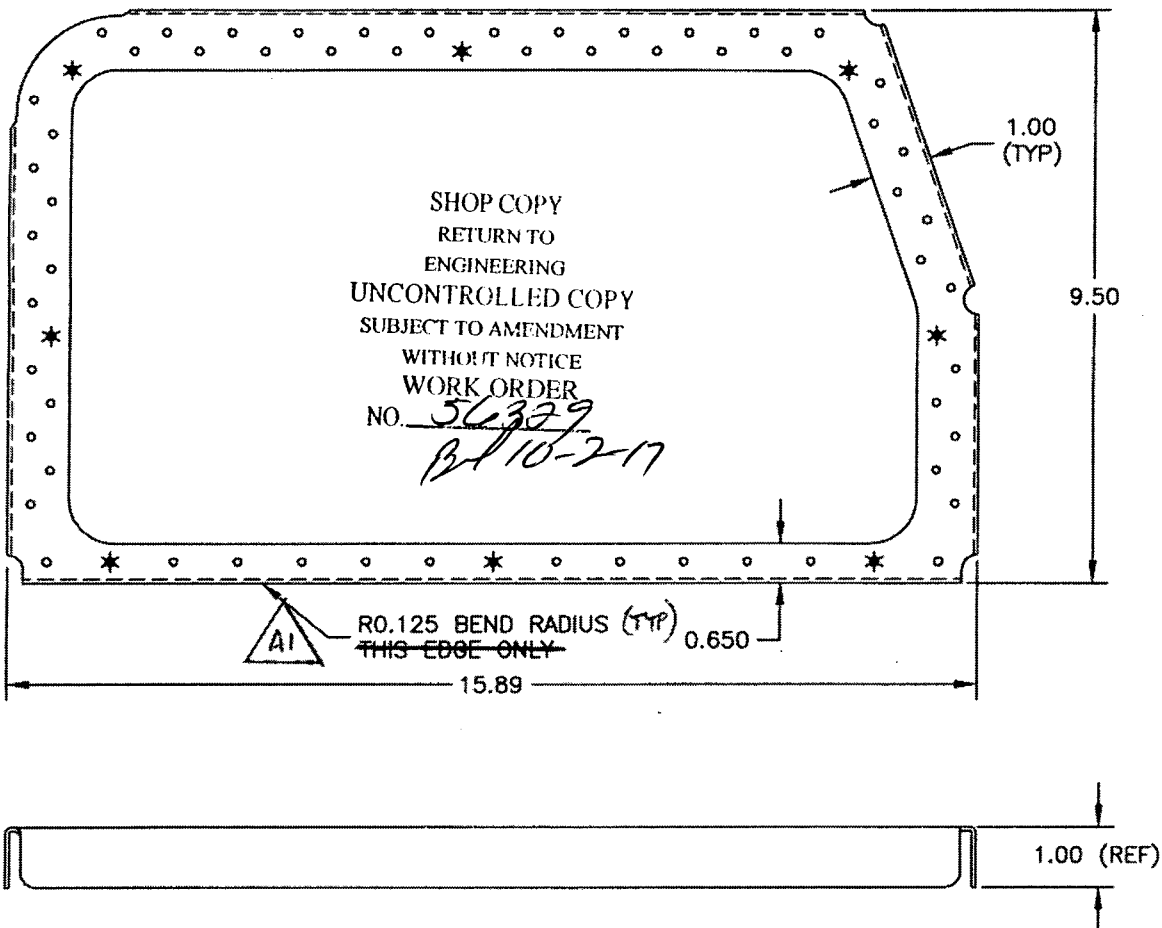
MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3

USE MINIMUM BEND RADIUS OF ~~0.188"~~ EXCEPT WHERE INDICATED ~~0.125"~~ 0.125"

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED





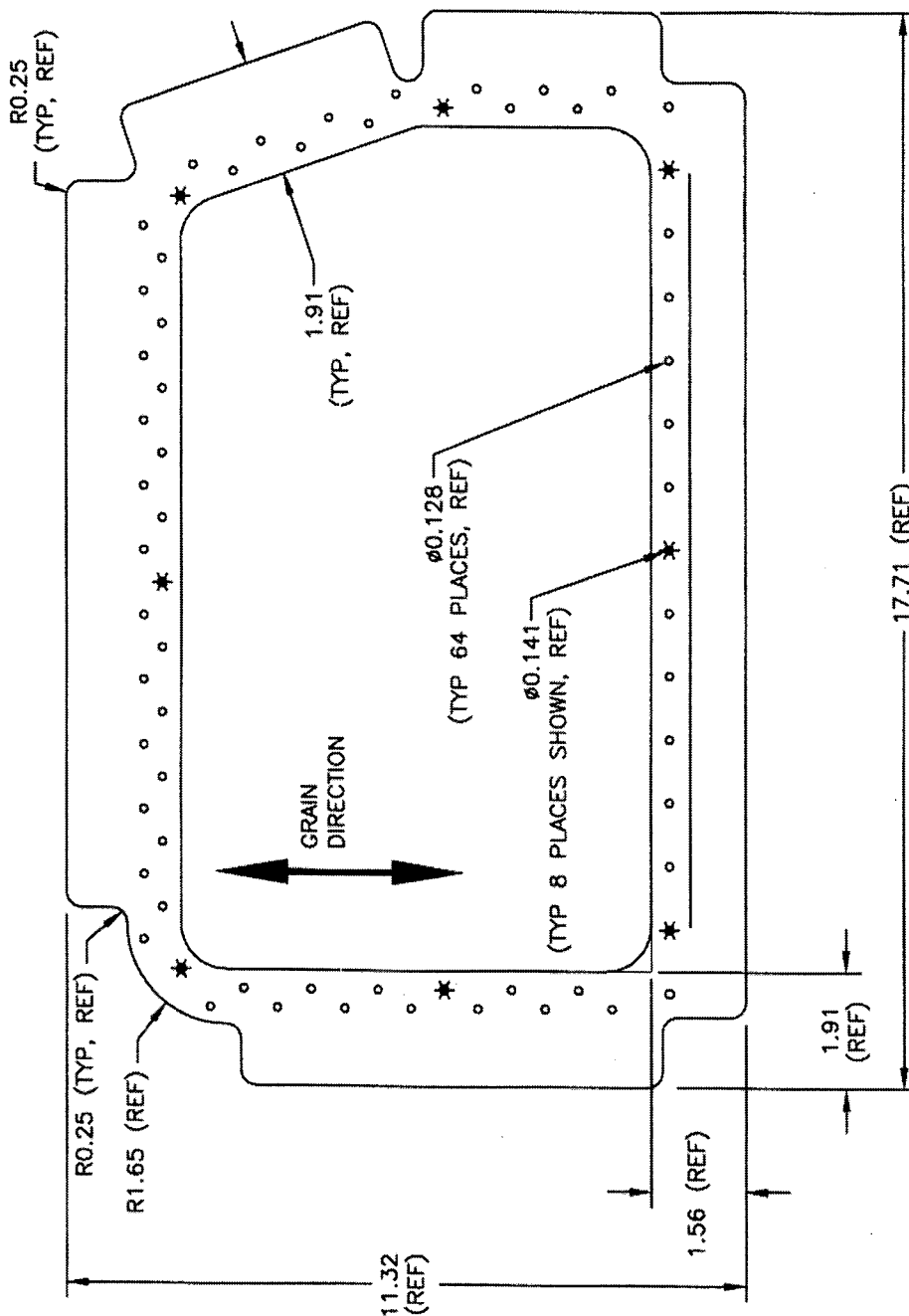
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3211	REV. A SHEET 2 OF 2
DATE 03.09.03		TITLE BRACKET	SCALE 1:3

RELEASED
03.09.03

DEO ATTACHED

W/0 56329

D3211-1 FLAT PATTERN



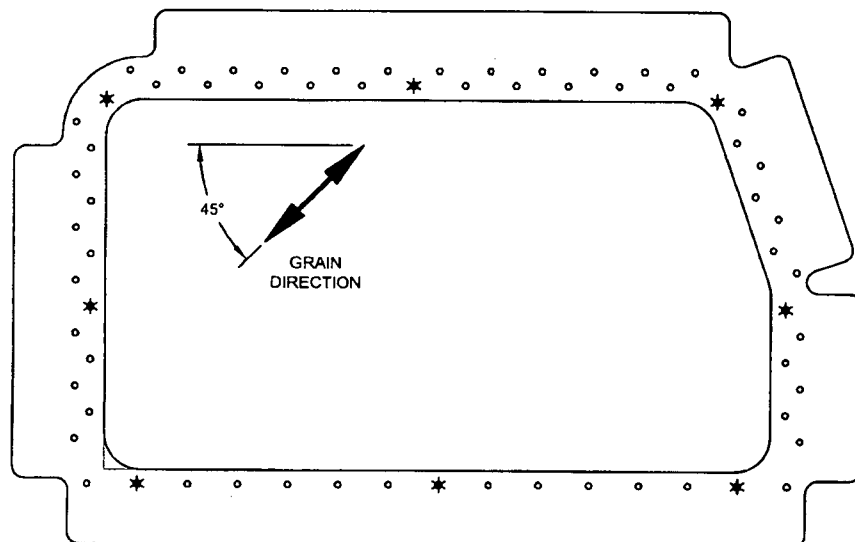
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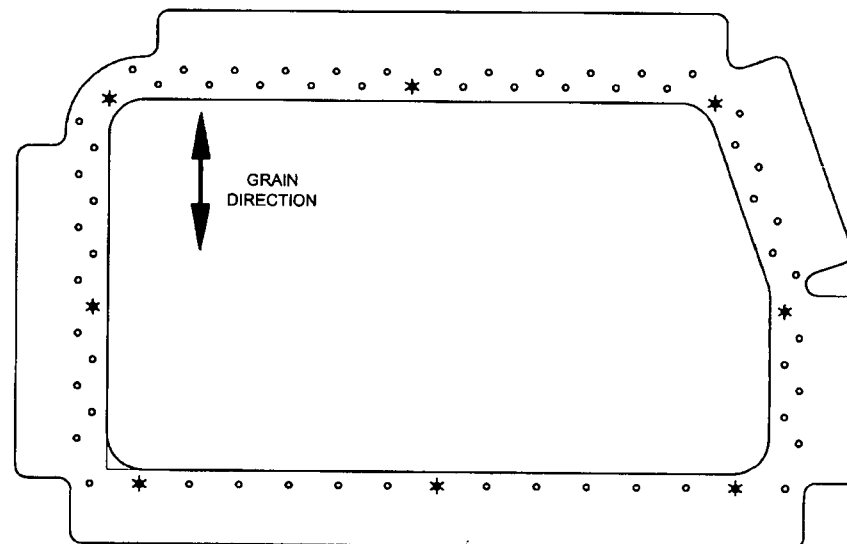
DRAWING NO. D3211	TITLE BRACKET	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3211-A-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>ls</i>	MFG. APPR. <i>RE</i>	APPROVED <i>MD</i>		DE APPR. <i>MT</i>		
DATE 08.09.12	DATE 08.09.12	DATE 08.09.12	DATE 08.09.12		DATE 08.09.12		

SHEET 2 MODIFY GRAIN DIRECTION AS SHOWN BELOW TO FACILITATE BENDING (SEE CAR 08-001).

IS:



WAS:



RELEASED
08.09.12 *MD*

ALL OTHER INFORMATION REMAINS UNCHANGED